



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
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Canada

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ASAP

**D3578-041**  
**Job Sheet 169138**



Part No: D3578-041

Job Qty: 40 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/4/17

Job Tracking No:

Due Date: 12/8/17

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A IPP: A 07.04.11 New issue EC IPP RevB 10.10.21 remove D3569-1 DD verf:JLM

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off       |
|-------|--------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|----------------|
|       |                    |        |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |                |
| 90    | Start up Operation | 40 Ea  | 12/7/17    | 12/7/17  | 0.00      | 0.00    | Start Up Waterjet     |           | ac 17/12/07    |
| 100   | Waterjet           | 40 pcs | 12/7/17    | 12/7/17  | 0.00      | 0.82    | Waterjet1             |           | ac 17/12/07    |
| 110   | QC                 | 40 pcs | 12/7/17    | 12/7/17  | 0.00      | 0.00    | QC2 Waterjet-2        |           | ac 17/12/07    |
| 120   | QC                 | 40 pcs | 12/7/17    | 12/7/17  | 0.00      | 0.00    | QC8-3                 |           | 38             |
| 130   | Small Fab          | 40 pcs | 12/7/17    | 12/7/17  | 0.00      | 0.68    | Small Fab-4           |           | 38             |
| 140   | QC                 | 40 pcs | 12/7/17    | 12/7/17  | 0.00      | 0.00    | QC5                   |           | 38             |
| 150   | HandFinish         | 40 pcs | 12/7/17    | 12/7/17  | 0.00      | 0.42    | HandFinish1           |           | 2017/12/12 JSC |
| 160   | QC                 | 40 pcs | 12/7/17    | 12/7/17  | 0.00      | 0.00    | QC7-2                 |           | 38             |
| 170   | Small Fab          | 40 pcs | 12/8/17    | 12/8/17  | 0.00      | 0.68    | Small Fab-4           |           | 38             |
| 180   | QC                 | 40 pcs | 12/8/17    | 12/8/17  | 0.00      | 0.00    | QC5                   |           | 38             |
| 190   | Packaging          | 40 pcs | 12/8/17    | 12/8/17  | 0.00      | 0.00    | Packaging3-1          | JF 040    | 9-88           |
| 200   | QC21-SA            | 40 Ea  | 12/8/17    | 12/8/17  | 0.00      | 0.00    | QC21                  |           | DAS 21         |

DEC 12 2017

### Job Allocations

| Operation             | Component Part     | Required | Inventory | Allocated | Std Qty |
|-----------------------|--------------------|----------|-----------|-----------|---------|
| 90-Start up Operation | MS20426AD3-3 (170) | 80       | 770       | 0         | 0       |
| 170-Small Fab         | M6061T6S.080       | 0        | 114       | 0         | 0       |
|                       | MS21075L3 (170)    | 40       | 0         | 0         | 0       |

FM137659-3

### Part Specifications

Specifications could not be found.

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                                             |  |                                                |  |                                                |  |                                     |  |                                              |  |                                              |  |
|---------------------------------------------|--|------------------------------------------------|--|------------------------------------------------|--|-------------------------------------|--|----------------------------------------------|--|----------------------------------------------|--|
| Work Order: _____                           |  | <b>DISPOSITION</b>                             |  | <b>AGAINST DEPARTMENT/PROCESS</b>              |  |                                     |  |                                              |  |                                              |  |
| Part No. _____                              |  | Rework <input type="checkbox"/>                |  | Skid-tube <input type="checkbox"/>             |  | Cross tube <input type="checkbox"/> |  | Water Jet <input type="checkbox"/>           |  | Engineering <input type="checkbox"/>         |  |
| NCR No. _____                               |  | Scrap <input type="checkbox"/>                 |  | Machining <input type="checkbox"/>             |  | Small Fab <input type="checkbox"/>  |  | Prod. Eng. Coord. <input type="checkbox"/>   |  | Quality <input type="checkbox"/>             |  |
|                                             |  | Use-as-is <input type="checkbox"/>             |  | Thermoforming <input type="checkbox"/>         |  | Finishing <input type="checkbox"/>  |  | Rec/Store/Packaging <input type="checkbox"/> |  | Other <input type="checkbox"/>               |  |
|                                             |  | Suspected Unapproved <input type="checkbox"/>  |  | Large Fab <input type="checkbox"/>             |  | Composite <input type="checkbox"/>  |  | Supplier <input type="checkbox"/>            |  |                                              |  |
| Date : _____                                |  | Step #: _____                                  |  | QTY Effective : _____                          |  |                                     |  |                                              |  | MRB (QSI042) Approval                        |  |
| Description Work Order Deviation            |  |                                                |  |                                                |  |                                     |  |                                              |  | Completed By                                 |  |
|                                             |  |                                                |  |                                                |  |                                     |  |                                              |  | Lead hand / Supervisor Approval Verification |  |
|                                             |  |                                                |  |                                                |  |                                     |  |                                              |  | Coordinator                                  |  |
|                                             |  |                                                |  |                                                |  |                                     |  |                                              |  | g<br>ons<br>rance<br>g<br>ce                 |  |
| <b>Root Cause</b>                           |  |                                                |  |                                                |  |                                     |  |                                              |  |                                              |  |
| Environment <input type="checkbox"/>        |  | No Re-verification <input type="checkbox"/>    |  | Pressure/Forced <input type="checkbox"/>       |  |                                     |  |                                              |  |                                              |  |
| Design <input type="checkbox"/>             |  | Operator <input type="checkbox"/>              |  | Bending <input type="checkbox"/>               |  |                                     |  |                                              |  |                                              |  |
| Doc/Data <input type="checkbox"/>           |  | Offset/Setup <input type="checkbox"/>          |  | Centre Not Concentric <input type="checkbox"/> |  |                                     |  |                                              |  |                                              |  |
| Equip/Tooling <input type="checkbox"/>      |  | Supplier <input type="checkbox"/>              |  | Cracks <input type="checkbox"/>                |  |                                     |  |                                              |  |                                              |  |
| Handling/Pre <input type="checkbox"/>       |  | Training <input type="checkbox"/>              |  | Crimp/Kink/Ripple/W <input type="checkbox"/>   |  |                                     |  |                                              |  |                                              |  |
| Material <input type="checkbox"/>           |  | Use for Testing <input type="checkbox"/>       |  | Cuffs <input type="checkbox"/>                 |  |                                     |  |                                              |  |                                              |  |
| Internal Transport <input type="checkbox"/> |  | Poor Information <input type="checkbox"/>      |  | Crushing <input type="checkbox"/>              |  |                                     |  |                                              |  |                                              |  |
| Tribal Knowledge <input type="checkbox"/>   |  | Rushing <input type="checkbox"/>               |  | Heat Treat <input type="checkbox"/>            |  |                                     |  |                                              |  |                                              |  |
| LOA <input type="checkbox"/>                |  | Product Improvement <input type="checkbox"/>   |  | Wave/Twist in Tube <input type="checkbox"/>    |  |                                     |  |                                              |  |                                              |  |
| Substation <input type="checkbox"/>         |  | Process Improvement <input type="checkbox"/>   |  | Marks/Chatter <input type="checkbox"/>         |  |                                     |  |                                              |  |                                              |  |
| Past Expiry Date <input type="checkbox"/>   |  | Manufacturing Process <input type="checkbox"/> |  |                                                |  |                                     |  |                                              |  |                                              |  |
| Misidentified <input type="checkbox"/>      |  | Past Due <input type="checkbox"/>              |  | OTHER : _____                                  |  |                                     |  |                                              |  |                                              |  |

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**DART**  
AEROSPACE

018682



Doublet

D3578-041

Start up Operation  
Mfg Date: 12/07/17  
Job No: 169138

PART NO:  
Revision:  
Operation:  
Change No:

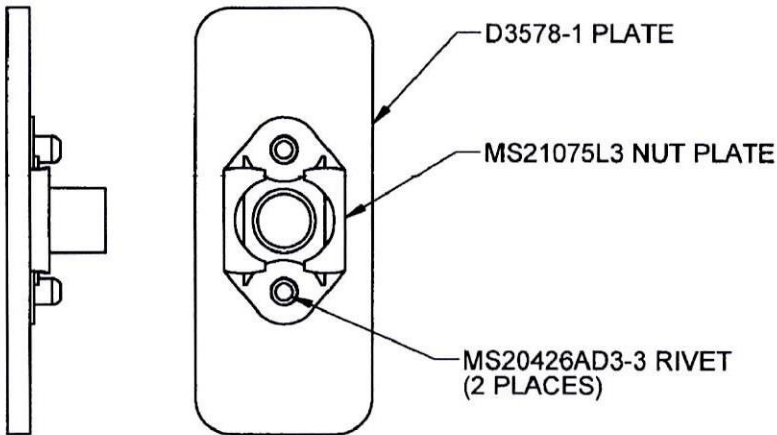
|                 |              |           |
|-----------------|--------------|-----------|
| Job Allocations |              | Inventory |
| Required        | Required     | Inventory |
| 80              | 80           | 770       |
| 0               | 0            | 114       |
| 40              | 40           | 0         |
| Component Part  |              | Inventory |
| MS20428A03-3    | MS20428A03-3 | 770       |
| ME061TGS-080    | ME061TGS-080 | 114       |
| MS21078L3       | MS21078L3    | 0         |





**DART**

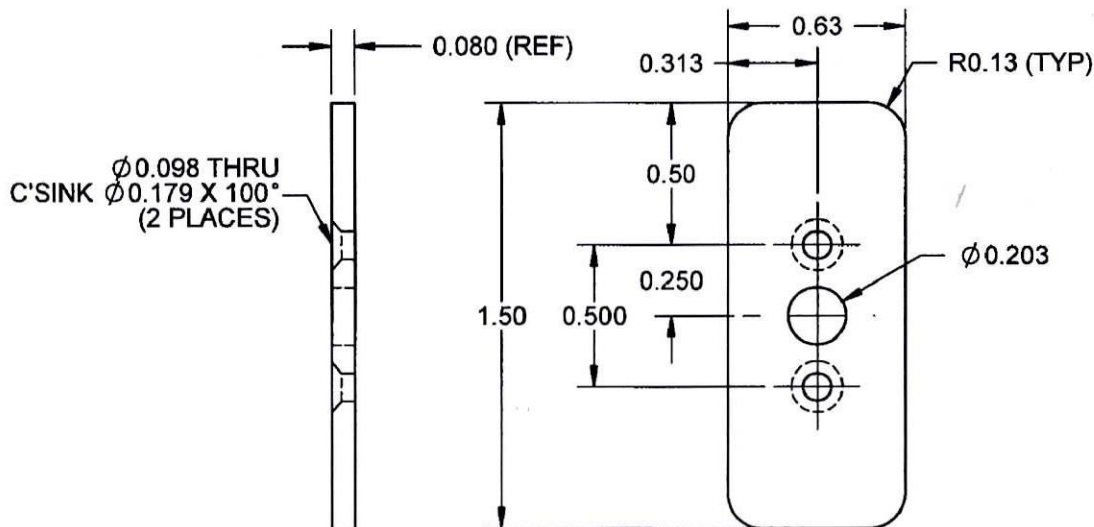
|                         |                       |                                                          |                        |
|-------------------------|-----------------------|----------------------------------------------------------|------------------------|
| DESIGN<br><i>LE</i>     | DRAWN BY<br><i>LE</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>JB</i>    | APPROVED<br><i>JB</i> | DRAWING NO.<br><b>D3578</b>                              | REV. A<br>SHEET 1 OF 1 |
| DATE<br><b>07.01.12</b> |                       | TITLE<br><b>DOUBLER</b>                                  | SCALE<br>3:2           |
| REV<br>A                | DATE<br>07.01.12      | DESCRIPTION<br>NEW ISSUE                                 |                        |

**RELEASED**  
07.04.02**D3578-041 PARTS LIST:**

| QTY | P/N          | DESCRIPTION |
|-----|--------------|-------------|
| X   | D3578-041    | DOUBLER     |
| 1   | D3578-1      | PLATE       |
| 1   | MS21075L3    | NUT PLATE   |
| 2   | MS20426AD3-3 | RIVET       |

**D3578-041 DOUBLER****D3578-041 NOTES:**

1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER

**D3578-1 PLATE****D3578-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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